

Work Order ID 66290

February 9, 2011 10:01:05 AM



Page 1

Item ID: D412-698-023

Accept



Setup Start



Revision ID:

Stop



Item Name: Automatic Door Opener, LH/RH

Start Date: 2/10/11 Start Qty: 4.00



Cust Item ID:

Required Date: 2/24/11 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: Maf Date: 11-02-09 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D412-698	Rev E

100 0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-698-023

CHG002

8/11/02/10

CL 11-02-10

110 0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/2/9 (40) sf

120 0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

8/11/02/10

(X40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-023								
	Location: <u>1B</u>								
	PPP Rev: <u>1B</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

140/10

40

11/02/10

MF
11-02-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Parent Item: D412-698-023





Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 2/10/11**Required Date:** 2/24/11

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-07-12 JLM
IPP rev B ecn 1207 08.07.03 EC verified by:LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD516L  Washer	NAS1149D0516J	Purchased	No			120	Each	59.0000	2	.8		11/2/98	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST347				59					
					112466			59					
D3552-11  Door Prop		Manufactured	No			120	Each	20.0000	1	.4		11/2/98	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST272				20					
					65130			8					
					65391			12					
D3594-043  Floor Doubler Assembly, LH		Manufactured	No			120	Each	16.0000	1	.4		11/2/98	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST234B				16					
					64084			1					
					65160			15					
D3594-044  Floor Doubler Assembly, RH		Manufactured	No			120	Each	19.0000	1	.4		11/2/98	Q
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST234B				19					
					64085			4					
					65161			15					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 66290

Parent Item: D412-698-023

Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 2/10/11

Required Date: 2/24/11

Start Qty: 4.00

Required Qty: 4.00

D3594-5

Manufactured No

120

Each

16.0000



Door Doubler

Location

Loc Qty

Loc Code

ST234A

16

58968

2

64086

14

120

Each

14.0000

D3622-1

Manufactured No



Ball Stud

Location

Loc Qty

Loc Code

ST070

14

65005

14

120

Each

3,078.000

MS20426AD4-4

Purchased No



Rivet

Location

Loc Qty

Loc Code

ST316

55

15541

55

ST317

3023

116188

3023

120

Each

81.0000

MS21073L5

Purchased No



nut plate

Location

Loc Qty

Loc Code

ST303

81

113660

61

116583

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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Revision: E
Date: 08.05.01